

Date: Tuesday, 28/11/2006 11:21:30 AM  
 User: Linda Lacelle

## Process Sheet

|                       |   |                  |                         |
|-----------------------|---|------------------|-------------------------|
| Customer              | : CU-DAR001 Dart Helicopters Services                         | Drawing Name     | : 205 SKIDTUBE "I" BEAM |
| Job Number            | : 29722   | Part Number      | : D2596                 |
| Estimate Number       | : 10346   | Drawing Number   | : D2596 REV C           |
| P.O. Number           | : N/A   | Project Number   | : N/A                   |
| This Issue            | : 28/11/2006  | Type             | : LANDING GEAR          |
| Prsh Rev.             | : NC  | Drawing Revision | : C                     |
| First Issue           | : N/A   | Material         | : N/A                   |
| Previous Run          | : 29604   | Due Date         | : 05/12/2006            |
| Written By            | :   | Qty:             | 12                      |
| Checked & Approved By | :   | Um:              | Each                    |
| Comment               | : Est: D 99.02.02 Changed QA to QC, Added Step 6 and Cost D M |                  |                         |

## Additional Product

Job Number:



| Seq. #:  | Machine Or Operation:                      | Description :   |
|----------|--|---|
| 1.0      | D25003100                                  | Ex'tn - 'I' Beam Web 4"   |
|          |  | <span style="float: right;">(12)</span>                         |
|          |  | <span style="font-size: 2em; float: right;">m-l 06/11/28</span> |
|          |  | <span style="font-size: 1.5em; float: right;">(12)</span>       |
| Comment: | Qty.: 1.0000 Each(s)/Unit                  | Total : 12.0000 Each(s)   |
|          | Extrusion "I" Beam Web 4"                  |   |
| Pick:    |  |   |
| Qty      | Part Number                                | Description   |
| 1        | D2500-3-100                                | Extrusion   |
|          |  | Batch <u>1325751</u>  |
| 2.0      | LANDING GEAR 1                             | LANDING GEAR RESOURCE 1   |
|          |  |   |
|          |  | <span style="font-size: 1.5em; float: right;">(12)</span>       |
|          |  | <span style="font-size: 2em; float: right;">m-l 06/11/29</span> |
|          |  | <span style="font-size: 1.5em; float: right;">(12)</span>       |
| Comment: | LANDING GEAR RESOURCE 1                    |   |
|          | 1- Cut D2500-3-100 to length: 99.5"        |   |
|          | 2- Use Jig DT8093 to drill pilot holes #30 |   |
|          | 3- Open to 0.625" diameter using a uni-bit |   |
|          | 4- Deburr                                  |   |
| 3.0      | HAND FINISHING1                            | HAND FINISHING RESOURCE #1                                      |
|          |  |   |
|          |  | <span style="font-size: 1.5em; float: right;">(12)</span>       |
|          |  | <span style="font-size: 2em; float: right;">m-l 06/11/29</span> |
|          |  | <span style="font-size: 1.5em; float: right;">(12)</span>       |
| Comment: | HAND FINISHING RESOURCE #1                 |   |
|          | Acid Etch and Alodine per QSI 005 4.1      |   |
| 4.0      | QC5  | INSPECT WORK TO CURRENT STEP                                    |
|          |  |   |
|          |  | <span style="font-size: 1.5em; float: right;">(12)</span>       |
|          |  | <span style="font-size: 2em; float: right;">m-l 06/11/29</span> |
|          |  | <span style="font-size: 1.5em; float: right;">(12)</span>       |
| Comment: | INSPECT WORK TO CURRENT STEP               |   |

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 06/11/09  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

Date: Tuesday, 28/11/2006 11:21:30 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 205 SKIDTUBE "I" BEAM

Job Number: 29722

Part Number: D2596

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

|     |             |                       |
|-----|-------------|-----------------------|
| 5.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
|-----|-------------|-----------------------|



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: LG

m-h 06/11/29 (12)

|     |      |                              |
|-----|------|------------------------------|
| 6.0 | QC21 | FINAL INSPECTION/W/O RELEASE |
|-----|------|------------------------------|



Comment: FINAL INSPECTION/W/O RELEASE



(12) SP 06/11/29

Job Completion



C Loc 11129

Dart Aerospace Ltd

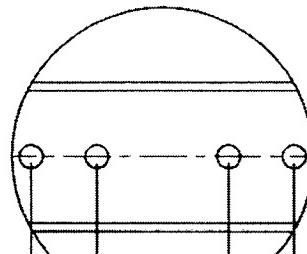
| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

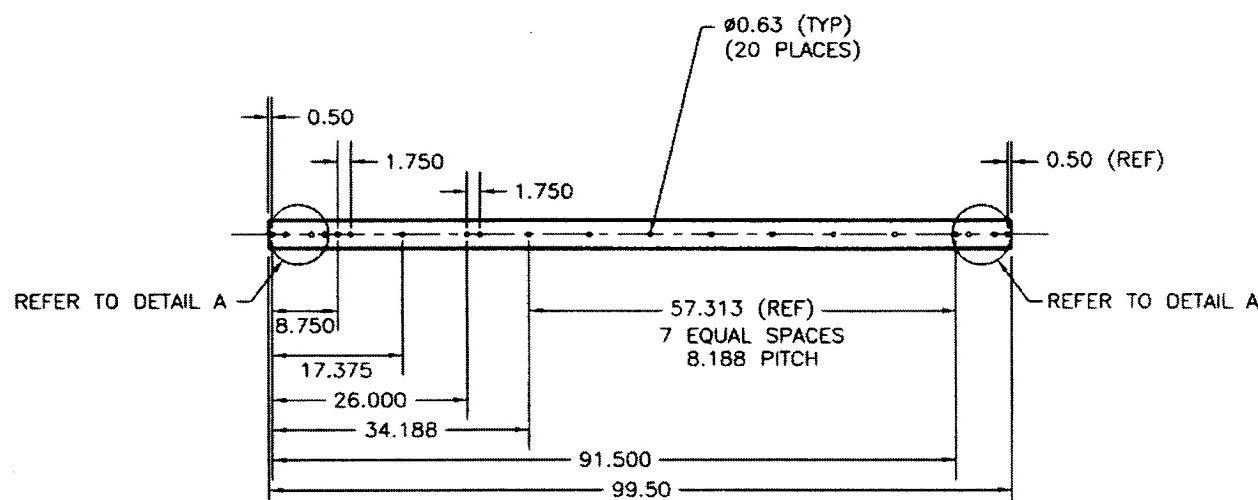
| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

DETAIL A  
SCALE 5:24



1.750 3.500 1.750



MANUFACTURED FROM D2500-3 EXTRUSION  
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

WJQ 29/22

RELEASED  
18-09-11 DS

**DART**



| DESIGN   | DRAWN BY | DART AEROSPACE LTD          |
|----------|----------|-----------------------------|
| CHECKED  | APPROVED | HAWKESBURY, ONTARIO, CANADA |
| DATE     |          | DRAWING NO.                 |
| 98.09.14 | JG       | D2596                       |
| A        | 96.09.16 | 205 WEB                     |
| B        | 97.07.23 | Ø0.63 HOLE WAS Ø0.56        |
| C        | 98.09.14 | INCORPORATED DEO 9097       |

REV. C  
SHEET 1 OF 1  
1:24

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
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|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries